

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010277**Date Inspected:** 22-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Chuan Qing.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 10, South tower, Lift 4, Stiffener to Diaphragm.

FCAW welding of weld joint SSTL4-1J/L-101; located on Bay 10, South tower, Lift 4. Welders are identified as 037907; ZPMC Quality Control Inspector (QC) is identified as Wang Chuan Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-4332-TC-P4-F.

Bay 11, East Tower, Lift 4, B/C Corner.

During random visual inspection at East Tower, Lift 4(Temporary Attachment Area near Corner Seam B/C) this Caltrans Quality Assurance (QA) Inspector observed "Crack Like" indications at the removed Temporary attachment Weld area. The indications were shown to ZPMC and ABF QC Inspectors. No Incident Report has been written on this issue. The attached photographs provide additional detail. This QA Inspector carried out NDE on following

Bay 10, West Tower, Lift 3, Corner seams.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an

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MT report (TL-6028) for this date. The members are identified as

- 1) WSTL3-4B/K-81B. A/E corner, Excluding Double Diaphragm area. GREEN TAG # 10455.
- 2) WSTL3-4B/K-84B. B/C corner, 1330mm Length from the Top, & Rotation ring areas. GREEN TAG # 10434

Bay 11, South Tower, Lift 4.

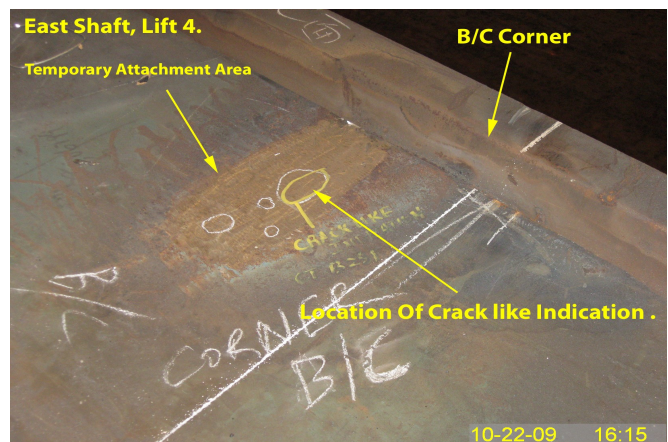
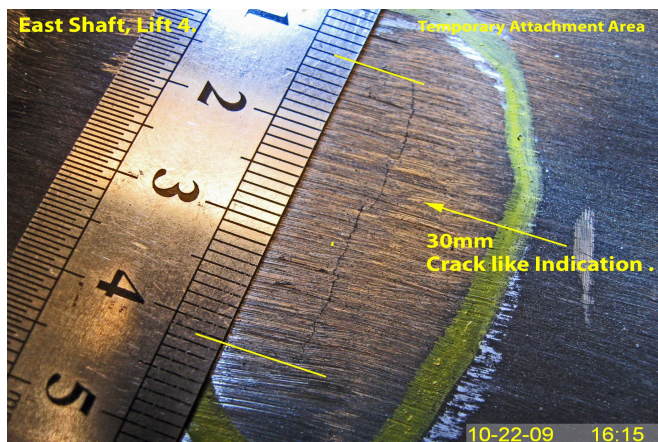
This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report (TL-6027) for this date. The members are identified as

- 1) SSTL4-1G/L-136A/B. 127M Diaphragm.
- 2) SSTL4-1F/L-137A/B. 123M Diaphragm.

Bay 11, East Tower, Lift 4, B/C Corner Seam(Work Piece area).

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT & UT report (TL-6028) for this date. The members are identified as ESTL-2B/L-58.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

Inspected By: Juvekar,Amit

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer